

Work Order ID 66043

Thursday, February 03, 2011 7:32:51 AM



Item ID: D2934

Accept



Setup Start



Revision ID:

Item Name: Saddle Spacer

Stop



Start Date: 2/3/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 2/4/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-02-03

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2934

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2934
Deburr if necessary

Dwg Rev: *B* Prog Rev: *B* 2-

6661-000

B11-2-7



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-2-7

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sublog

count
430

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Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

30 p del 11/02/08

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

30 PR 11-02-8.

150

Identify as per dwg & Stock Location: 29

0.00



Packaging

Memo

0.00

Packaging

11 k/45 30X count

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Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/09
MF
11-02-09

Picklist Print

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Page 1

Work Order ID: 66043

Parent Item: D2934

Parent Item Name: Saddle Spacer



Start Date: 2/3/2011

Required Date: 2/4/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A:00.06.06 New Issue:IECH
IPP Rev:B Now 6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.080

Purchased

No

100

sf

258.7000

0.0318

0.669474

1.



B11-2-7

6061-T6 .080 Sheet

Location

Loc Qty

Loc Code

MAT

258.7

116268

66.7

116700

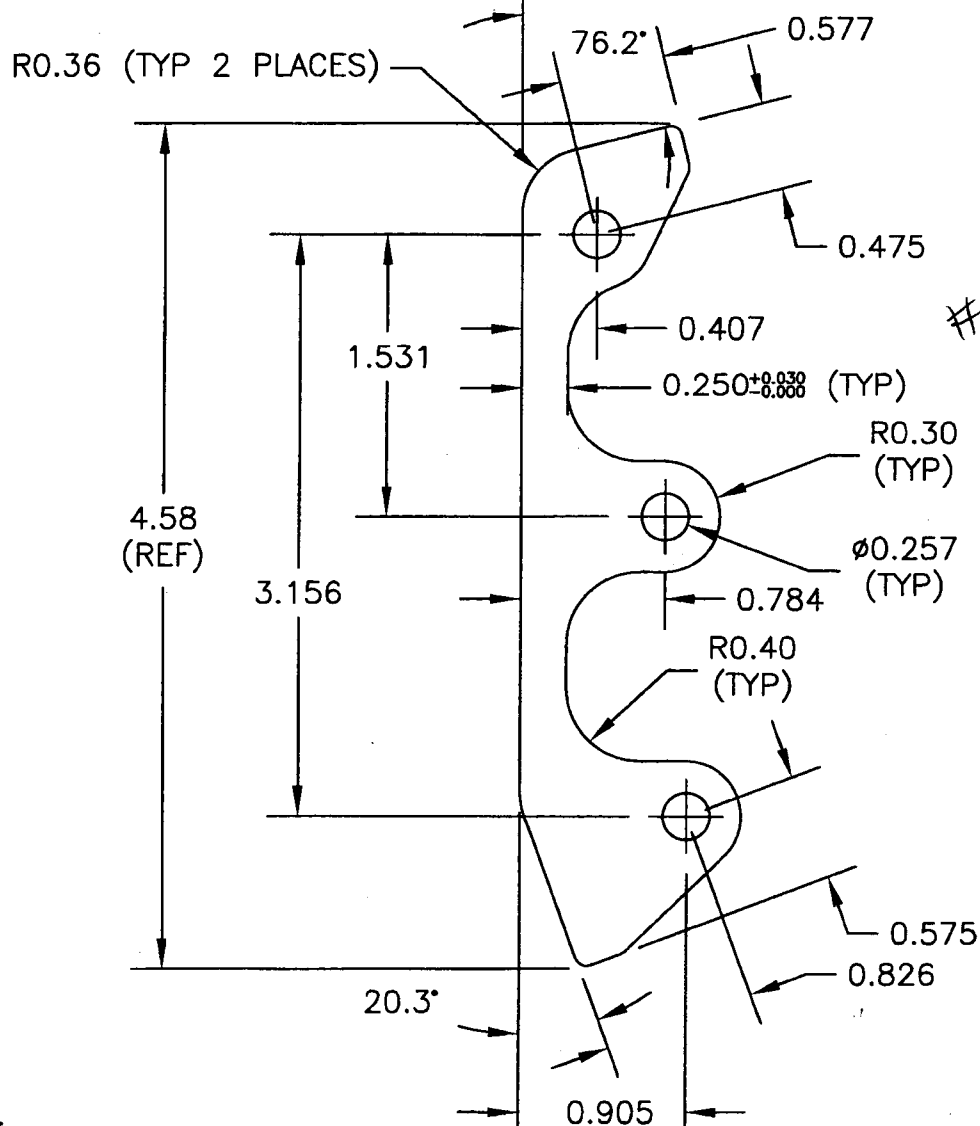
192

116268

30

DART

DESIGN 7#	DRAWN BY C.B.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2934	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK (REF DART SPEC M6061T6S.080) OR 5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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